

Work Order ID 86096

June-20-12 2:48:26 PM

86096

Page 1

Item ID: D3022-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Seat Pan

Stop *NS2*

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3022

Rev B

②

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022

2024.032

Dwg Rev: B

Prog Rev: B

*** grind direction along 31.700" ***

2-Deburr if necessary

B12-6-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-6-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86096

Page 2

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 20/06/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 04/07/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____

Date:

Tooling: _____ Date: _____

Date:

Stop *NR2*

QC: _____

Date:

SPC (Y/N): _____ Date: _____

Date:

[illegible]

Dart Aerospace Ltd

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Page 3

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Accept

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Setup Start ***NS1***

Revision ID:

Item Name: Seat Pan

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Start Date: 20/06/2012 Start Qty: 1.00

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1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

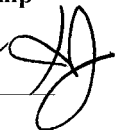
210

QC

Memo

0.00

Quality Control

12/6/28 

MF 12-06-27

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NOTE: Date & initial all entries

Picklist Print

June-20-12 2:48:30 PM

Page 1

Work Order ID: 86096

86096

Parent Item: D3022-1

D3022-1

Parent Item Name: Seat Pan

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23Revised NG

IPP Rev:D 08-04-16 now water jet DD verified by:EC

IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	188.2481	1.6232	1.708632	3.		

M2024T3S 032

2024-T3 .032 sheet

**

B12-G-24

Location

Loc Qty

Loc Code

MAT022

188.2481

118243

16.2481

118523

73

121309

99

121909

②

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NOTE: Date & initial all entries

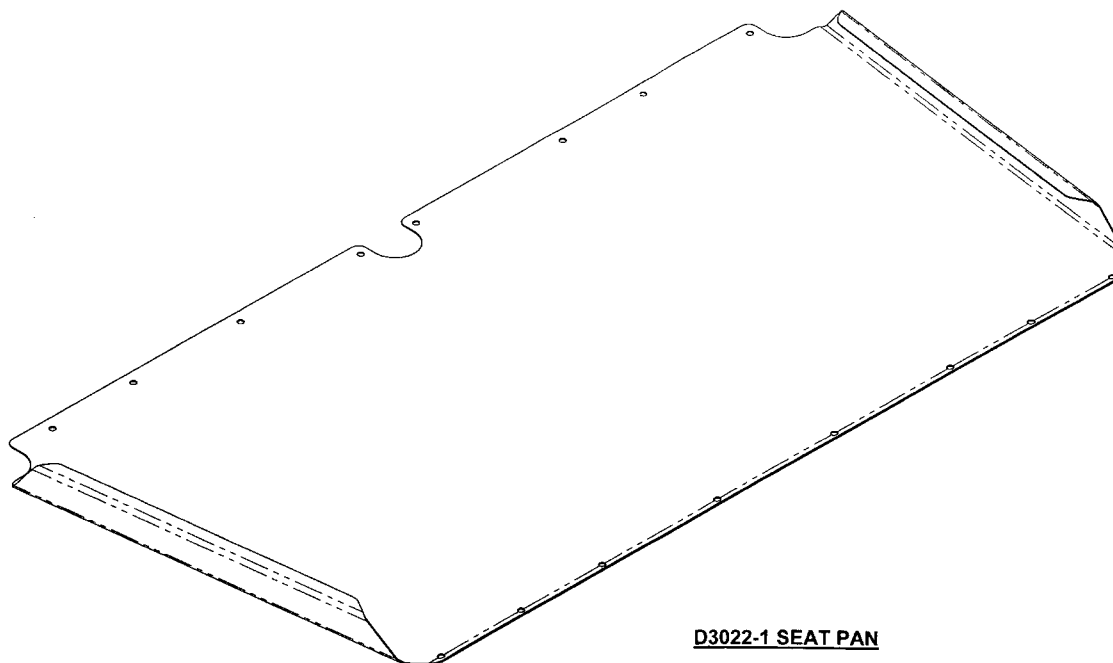
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D3022-1 SEAT PAN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86096 MLJ

12/06/20

RELEASED
08/12/15 MLJ

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED. D7-3 12.075 WAS 12.325. D8-3 5.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 REV. B SHEET 1 OF 3 TITLE SEAT PAN SCALE NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.27			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

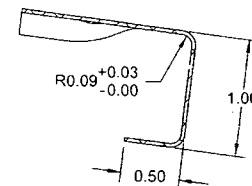
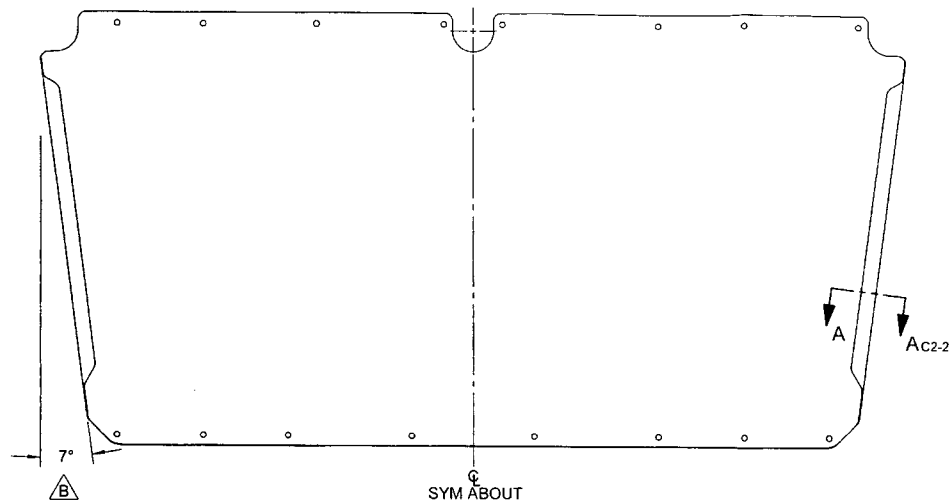
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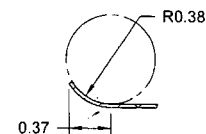
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26096



SECTION A-A C4-2
SCALE 4X



SECTION B-B A5-2
SCALE 4X

D3022-1 SEAT PAN

- NOTES:
- 1) MATERIAL: MAKE FROM D3022-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.36 lbs

RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE SEAT PAN	SCALE
DE APPR.			NTS
DATE	08.11.27	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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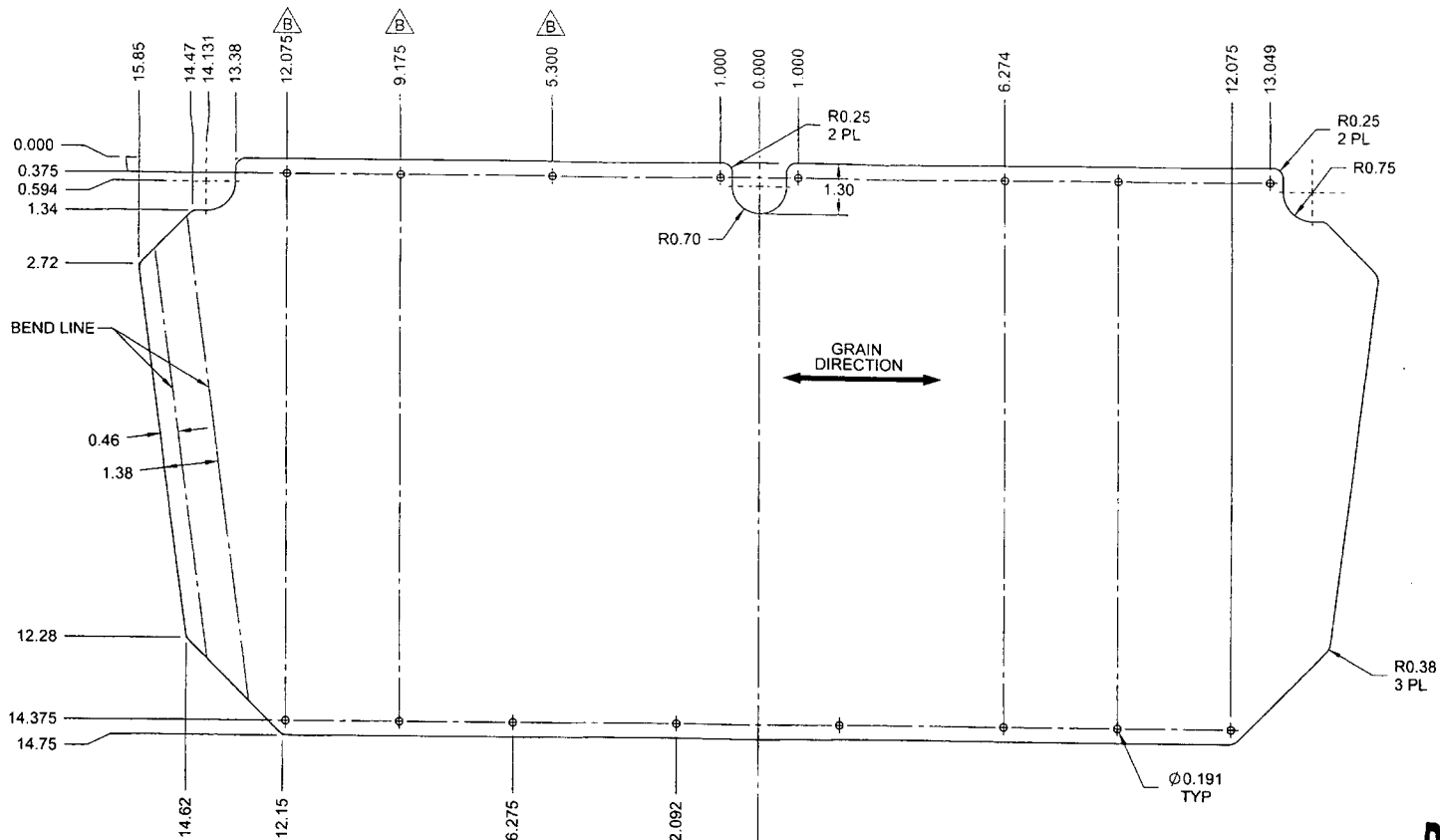
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NOTE: Date & initial all entries

06096



SYM ABOUT
UNLESS OTHERWISE
NOTED

D3022-1F SEAT PAN

RELEASED
28/12/15 JAV

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
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